

Work Order ID 119825

May-26-14 1:53:36 PM

119825

PRELIMINARY ISSUE

Page 1

Item ID: D4973-1

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Cutter Deflector

Start Date: 5/26/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/26/14 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: MCS

Date: 140526 Tooling:

Date:

Stop

NR2

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4973	<u>4040/14.05.26</u>	0.00							DAS 37 9-89
100	FLOW WATER JET	0.00							<u>14.05.27</u> mm
100									
Waterjet	Memo								
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 37 9-89
110		0.00							<u>14.05.27</u> mm
QC	Memo								
Quality Control									
114		0.00							
114		0.00							
Mill Conv	Memo								
Conventional Milling Machine	DRILL HOLES AS PER DWG MILL STEP AND BOTTOM FACE								

Scrap Old
Rev
Destroy

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119825

Page 2

May-26-14 1:53:36 PM

Item ID: D4973-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Cutter Deflector

Start Date: 5/26/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/26/14 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
116	QC2- Inspect parts off machine FAI/FAIB	0.00							
116									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

[Handwritten signature]
APR 14 7:31

119825

May-26-14 1:53:36 PM

N900040100

Setup Start *NS1*

Stop ***NS2***

Cust Item ID:

Start Date: 5/26/14 **Start Qty:** 1.00 ***1***

Required Date: 5/26/14 **Req'd Qty:** 1.00 ***1***

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

Work Order ID 119825

119825

Page 4

May-26-14 1:53:36 PM

Item ID: D4973-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Cutter Deflector

Start Date: 5/26/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/26/14

Req'd Qty: 1.00

1

Customer:

Reference:

Run

Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 4/25/14 AUTH U

RELEASED _____ DATE _____

Picklist Print

Page 1

May-26-14 1:53:42 PM

Work Order ID: 119825

119825

Parent Item: D4973-1

D4973-1

Parent Item Name: Upper Cutter Deflector

Start Date: 5/26/14

Required Date: 5/26/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 13-11-19 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B0.375X8.000		Purchased			No		f	14.8493		2			

M7075T6B0 375X8 000

7075-T6 BAR 0.375" X 8.000"

**

mm 14/05/27

Location

Loc Qty

Loc Code

MAT001

14.8493

123611

2

125428

2

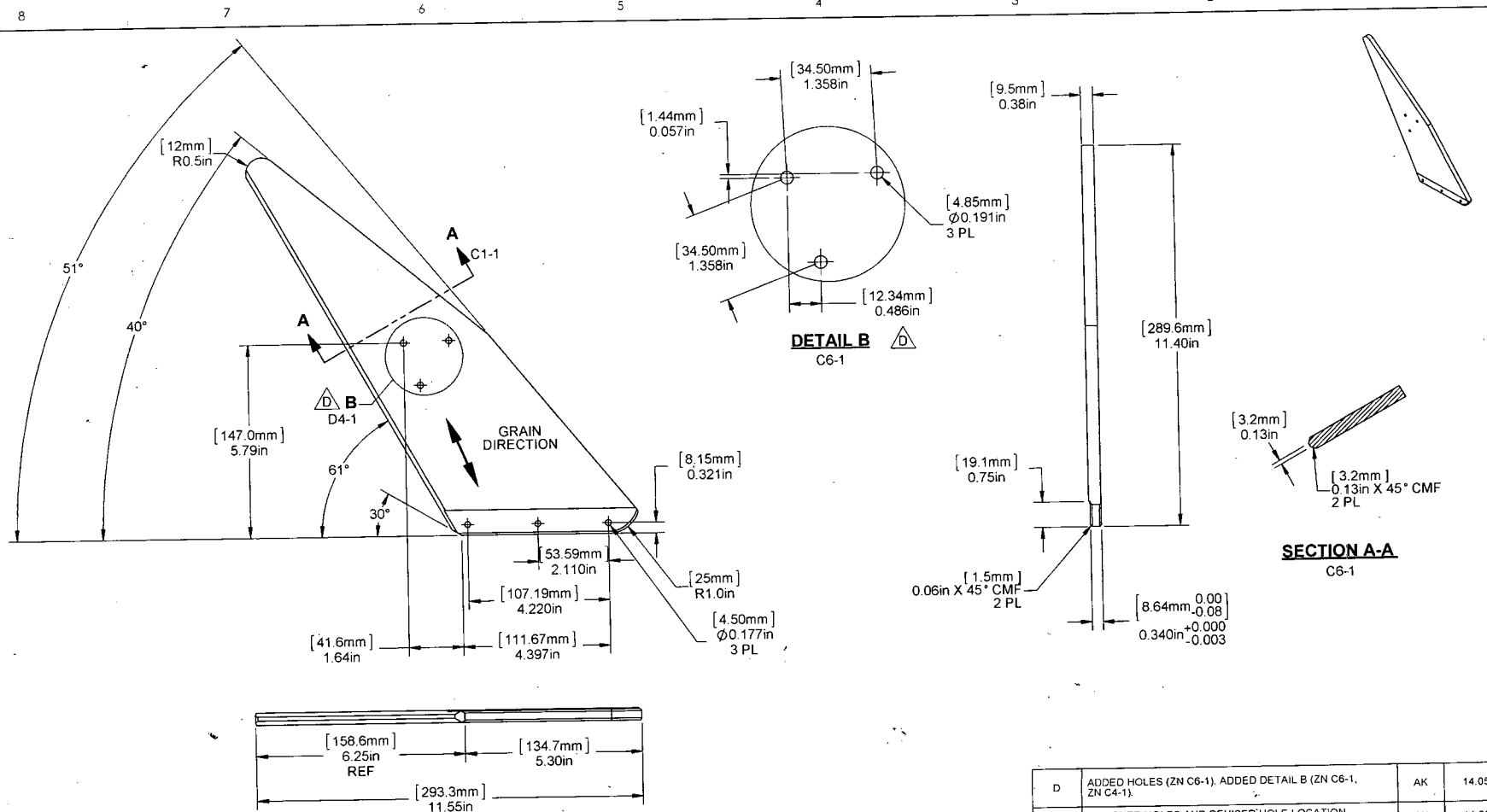
m126390

2.6242

m128502

8.2251

6



NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4973-1", AGUSTA WESTLAND P/N "TBD", REVISION, BATCH NUMBER AND DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
- 7) WEIGHT: 1.70 lbs (0.77 kgs)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4973-1-d.IGES

D	ADDED HOLES (ZN C6-1), ADDED DETAIL B (ZN C6-1, ZN C4-1)	AK	14.05.26
C	REMOVED HOLES AND REVISED HOLE LOCATION (ZN C6-1), REMOVED DETAIL B	AK	14.05.21
B	ADDED HOLES TO D4973-1	AK	14.05.06
A	NEW ISSUE	DC	13.11.11
REV	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	MFG. APPR.	DRAWING NO.	REV. D
APPROVED	DE APPR.	TITLE	SCALE
DATE	14.05.26	UPPER CUTTER DEFLECTOR	NTS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119825 MCL5
140526